

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002073**Date Inspected:** 02-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG				

Summary of Items Observed:

UT-DP042-002 and DP108-002

This Quality Assurance (QA) inspector arrived at ZPMC for observation of the SAS super structure fabrication and performed Ultrasonic Examination (UT) on the closed rib Partial Joint Penetration (PJP) weld joints. This Verification was performed after ZPMC performed there UT testing. This QA inspector completed the UT verification and documentation for DP042-002 there was multiple locations noted that was less than 9.6mm of Depth Of Penetration (DOP) these areas have been documented on UT report 6027 MOB for closed rib PJP welds. After completion of DP042-002 this QA inspector proceeded to DP108-002 for QA UT verification and completed approximately 50 to 60% of the welds tested by ZPMC. ZPMC was required by the special provisions to perform 15% UT for each weld length. ZPMC has calculated 3 areas to be tested for each weld which was an 800mm section on both ends of the weld and one 800mm section at approximately the half way point of each weldment. This QA inspector has performed an UT verification of 100% for each section that ZPMC has tested and noted that ZPMC has noted approximately 98 to 99% of the rejected area. This QA inspector was not able to complete the UT verification for this deck panel and informed the Task Leader and the night shift lead inspector of what needs to be completed. Night shift lead confirmed the locations to be completed with this QA inspector.

Summary of Conversations:

No conversations noted today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Pat Lowry, (858) 344-2712, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By:	Riley, Ken	Quality Assurance Inspector
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Reviewed By:	Hager, Craig	QA Reviewer
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